QC9- Inspect visual per QSI004- Fusion Welds 0.00 0.00

4- Weld D4672-1 blanking plates as per dwg

13-07.10

Quality Control

Memo

NCR: Ye	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:													
,	<del></del>					$\overline{}$	<del></del>					.e:		
Work Order					DISPOSITION			AGAINST	DEP	PARTMENT	/PROCESS			
				<del></del>	Rework	7	9	Skid-tube Crosstube			Water Jet		Engineering	
Part No	o				Scrap	]		//achining Small Fab			d. Eng. Coor.		Quality	
					Use-as-is	Th		oforming Finishing	$\vdash$	Rec/Stor	e/Packaging	_	Other	
NCR No	0				Work Order Update	]	l	Large Fab Composite			Supplier			
Root				Descri	ption of work order update	Initia	al	Action	T	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Description		Date	Verification	n ]	QC Inspector	
oc/Data														
quip/Tooling						1	1		İ		I I			
perator		ļ									1			
//aterial		İ					.		1					
etup							ļ							
Other		]					Ì		l					
rocess														
Supplier												ļ		
raining							ļ							
Inapproved					<u>,,</u>									
					• ,	AULT C	ATEG	GORY						
Landin	g Gear				General									
ſ	Bending				Bend	Gra	ain			Ovalized			Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s 🗍	BOM/Route	Har	dwar	re		Over/Under	tolerance		Temperature/Cure	
	Cracks				Broken/Damaged	Insp	pectio	on Incomplete		Part Incorre	ct		Weld	
Ī	Crushed/	Crimped			Burrs	Inst	tructi	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled	
	Cuffs				Contamination	Ma	inte	nance		Part Moved	·			
. [	Heat Trea	at			Countersink	Mis	slabel	led	П	Positioned V	Vrong			
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	sread		П	Power Loss/	Surge		Other	
F	Ripples ir				Drill Holes	Offs	set	'			'			
j	Torque W		Extrusio	n	Drawing	Out	t of C	Calibration	•		<del></del>			
• ]	Turning S				Finish	Out	t of S	equence	•					
	Wave/Tw				Folio	Out	tside	Dimensions	•					

DQA:

Date:

i.e.	·	
<b>XX</b> 7.	ork Order ID	103100
.VV (	irk Oraer III	102107
	JIM OTHER ID	
ì	25 12 2 11 11 11 11	

Hand Finishing

<b>Work Ord</b> <i>May-27-13 8:4</i>		2108		*102	2108*						Page 2
Item ID: Revision ID:	D3913-041			Accept	*N900	040	100	<b>)*</b> s	Setup Sta	1.7	S1*
Item Name:	Long Basket	Base Assemby, 350							Sto	<sup>p</sup> *N	S2*
Start Date:	5/27/13	Start Qty: 1.00	*1*		Cust Item 1	D:					
Required Date	e: 6/05/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:			7								* 1
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:		F	Run Sta	!/	R1*
	QC:		Date:	_ SPC (Y/N):	D:	ate:			Sto	<sup>р</sup> *N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part compl	eteness to step on W/O	0.00							OAO
*120* QC Quality Control		Memo		0.00					13-0	01.10	0A5 09
. 125		Pressure Wash per QS10	05 4.3	0.00				į	2	B 17	2. IN
*125* HandFinish		Mema		0.00					1 LE	715-	7.10

									DQA:	Date	):
NCR: Yes	s / No				WORK ORDER NON-C	CONFO	RMANCE / UPI	DATE	QA Closed:	Date	::
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No.	•				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube  Machining ermoforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance	Initia Chief E		tion ription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other Process Supplier Training Unapproved		·									
					F.	AULT CA	ATEGORY				
Landing	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in I	Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Inst Inst Ma Mis Mis Offs	dware pection Incomplete ructions Incomplete/lintenance labeled read set	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Turning S Wave/Tw	•		-	Finish Folio	$\vdash$	of Sequence side Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order  May-27-13 8:41:41		2108			Page 3						
Revision ID:	913-041			Accept	*N900	<b>0401</b>	I	Setu	p Start Stop	14.21	
Start Date: 5/27/13 Required Date: 6/05/13 Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			эсор	*NS2*	
Approvals: Process Pl		n:	Date:			nte:		Run	Start Stop	"NR1"	*
		coat  1ST COAT: START TIM OVEN TEM FINISH TIM ********** 2ND COAT: START TIM	and mask only interior  E:	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder		Tool# I	Code Qt		mf	Reject Insp. Number Stamp  13/07//	\(\delta\)
*140' *140* QC Qualify Control		QC3- Inspect Part Finish  Memo	d'40	0.00			_	6	<u></u>	L 13-7-10.	, books

NCR:	Yes	/	No
		-	

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR. 1	es / INU				AAOWK OVDEK 14014-	CONTO	MINIARCE / OF	DAIL	QA Closed:	Date:	
Work Orde	<del>ċ.</del>		• •		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap	]	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor	Engineering Quality
NCR N	0				Use-as-is Work Order Update	_   The	ermoforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root			-	Descr	iption of work order update	Initia	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	ription	Date	Verification	QC Inspector
Ooc/Data										:	
quip/Tooling						ļ					
Operator						1					1
Material				:							
Setup	_					1					
Other		ļ									
Process											
Supplier		1									
Fraining											
Jnapproved											
<u> </u>						FAULT CA	TEGORY				
Landin	g Gear				General			<b></b>	-	_	<u> </u>
	Bending				Bend	Gra	n		Ovalized		Pressure/Forced
{	Centre N	ot Concei	ntric to	o/s	BOM/Route	Hard	lware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
, [	Crushed/	Crimped			Burrs	Instr	uctions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
7	Cuffs				Contamination	Mai	ntenance		Part Moved		
4	Heat Trea	at			Countersink	Misl	abeled		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
[	Ripples in	n Bend			Drill Holes	Offs	et				
	Torque V	Vaves in E	Extrusio	n [	Drawing	Out	of Calibration				
	Turning S	Sequence			Finish	Out	of Sequence				
	Wave/Tv	vist in Tul	эe	Γ	Folio	Out	side Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ordo</b> <i>May-27-13 8:41</i>		02108		*102	2108*							Page 4
Item ID:	D3913-041			Accept	*N900	040	100	*	Setup	Start	*N!	R1*
Revision ID:		D A								Stop	*816	`` <b>`</b> `
Item Name:	_	Base Assemby, 350									*N.	ラン" 。
Start Date:	5/27/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date: Reference:	6/05/13	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:			Run	Start	*NF	₹1*
•	QC:		Date:	<b>SPC (Y/N):</b>	D:	ate:				Stop	*NF	₹2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp
150		Assemble as per dwg		0.00						,	,	
*150* HandFinish		Memo		0.00					- 4		13-3	7-11
Hand Finishing		Pick Kit										'e.
160		QC5- Inspect part compl	eteness to step on W/O	0.00							1	(DAS
*1.60* QC Quality Control		Memo		0.00			-	/				05 / /3 0
Sample Control								v :	ę.			
170 **4 <b>7</b> 0*		Identify as per dwg & St	ock Location: \( \sum_0030	OH.00	102104.			j		ch .	H 12	276
Packaging		Memo		0.00						4	W 10	-(10).

\*Packaging

											DQA:	Date	::
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFOR	MANCE / UPDA		OA Clasadi	Data	
						1		_			QA Closed:		:-
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
						Rework	]		Skid-tube (	Crosstube		Water Jet	Engineering
Part N	۷o.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			•			Use-as-is	]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.		· · · · ·			Work Order Update	]		Large Fab C	Composite		Supplier_	
Root					Descri	ption of work order update	Π	Initial	Action	<u> </u>	Sign &		
Cause		Date	Step	Qty	ı	or Non-conformance		nief Eng			Date	Verification	QC Inspector
Doc/Data	П												
Equip/Tooling													
Operator													
Material									•				
Setup							1						
Other				1									
Process							1						
Supplier	Ш						1						
Training	Ш		ļ									<u> </u>	
Unapproved			<u> </u>	<u> </u>									
							AU	LT CATE	GORY	····			
Landi	ng G	Gear				General	_	7		<del></del>	i	<b>-</b> -	<b>-</b>
	Ш	Bending				Bend		Grain			Ovalized	L	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	$\perp$	Hardwa	are		Over/Under	tolerance	Temperature/Cure
		Cracks			L	Broken/Damaged	_	-1 '	ion Incomplete		Part Incorre	<b>}</b>	Weld
		Crushed/	Crimped			Burrs		-1	tions Incomplete/Unc	lear	Part Lost/M	_	Wrong Stock Pulled
	Ш	Cuffs				Contamination	L	Mainte	enance	<u></u>	Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	<b>N</b> rong	

Misread

Out of Calibration

Out of Sequence
Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

	Work Order ID 102108  May-27-13 8:41:41 AM  tem ID: D3913-041			*102	2108*							Page 5
Item ID: Revision ID:	D3913-041			Accept	*N900	<b>040</b>	100	<b>*</b>	Setup	Start Stop		S1*
Item Name:	Long Basket	t Base Assemby, 350								Stop	*N	S2*
Start Date:	5/27/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	6/05/13	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>					-		
Reference:			•									
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:					Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description	Wark Order Deleges	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	~	Reject Number	Insp. Stamp
180		QC21- Final Inspection	- Work Order Release	0.00					- 1	3/1	11/2	DXT
*1 <b>2</b> 0*		Memo		0.00						<u> </u>	112	
Quality Control											M	V
											1	3-7-11

											DQA:	Date	:
NCR: Y	'es	/ No				WORK ORDER NON-C	10:	<b>VFORM</b>	MANCE / UP	DATE			
											QA Closed:	Date	
Work Orde	·÷·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	-				<del></del>	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
•	_					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator											1		
Material							1						
Setup													
Other					•		Ì						
Process													
Supplier										•			
Training												ļ	
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General		_			-	_	=
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	O/S	BOM/Route		Hardwa	ire	<u></u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
	$\Box$	Heat Trea	it			Countersink		Mislabe	eled		Positioned \	Vrong	_
	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	Г	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Page 1

Work Order ID:

102108

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

**Start Date: 5/27/13** 

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV B DD VERF-EC

	verified by:EC	IPP RE	V:C 12	2.07.24 AS PE	ER DWG REV.	B DD VERI	:EC						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	563.0000	6	6	H	137	-11
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				GA		16							
				122	800	16							
				ST351		4							
				124	221	3							
				124	858	1							
•				ST512		43							
				122	800	43							
		•		ST513	/	500							
.1	1	/		m12	25709	500				6_			
AN960JD8 Washer	NAS1149DN832J	Purchased	No	بم د	910	150	Each	0.0000	2	ລ <sup>²</sup>	DE 13	2711	/
D2581 Mounting Bracket		Manufactured	No	12	3603	100	Each	60.0000	2	2 /	DC 13	· ~	/ //



Location	Loc Qty	Loc Code	
WA	6		
98503	6		
WA004	54		
101383	20		2
70766	2		
81253	1		
82506	2		
83230	3		
85452	2		
87706	2		
99067	12		
99837	10		

									•		DQA:	Da	te:	
NCR:	<b>Yes</b>	/ No				WORK ORDER NON-	COI	NFOR	VIANCE / UPDA	ATE				
						T					QA Closed:	Dat	te:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Ord	٠٠٠.					Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part I	No.					Scrap	1 !		Machining	Small Fab	Pro	d. Eng. Coor.	П	Quality
	•					Use-as-is	1		noforming	Finishing	Rec/Sto	re/Packaging	П	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	] ·	Supplier		
Root						ption of work order update	1	Initial	Actio		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descrip	tion	Date	Verification	n_	QC Inspector
Doc/Data							1						ļ	
Equip/Tooling							1							
Operator													1	
Material	Ш		İ											
Setup	L													
Other	L	,												
Process	L												ı	
Supplier			ļ										į	
Training	L		İ											
Unapproved							<u></u>							<u> </u>
							AUI	LT CATE	GORY					
Landi	ing (	Gear	•		_	General	_	7		_	7	1		1
	$\Box$	Bending				Bend	L	Grain			Ovalized		$\vdash$	Pressure/Forced
	<u></u>	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardware				Over/Under tolerance		<u> </u>	Temperature/Cure
		Cracks			ļ	Broken/Damaged	$\perp$	=1	ion Incomplete	<u> </u>	Part Incorre		igsqcup	Weld
1		Crushed/	Crimped		Į.	Burrs		Instruct	tions Incomplete/Un	clear	Part Lost/M	issing		Wrong Stock Pulled

Maintenance Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

May-27-13 8:41:39 AM

Work Order ID:	102108								
Parent Item:	D3913-041							Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base Assemby,	350					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
D2931 Bumper	Manuf	actured	No		150	Each	2,188.0000	2	2 BL 13-7-11
	• •		Lo	<u>cation</u>	Loc Qty		Loc Code		
			GA		190				
				46064	190				
			ST		1998				
				86435	1998				<b>- /ノ</b>
D3913-1	Manuf	actured	No		100	Each	5.0000	1	1(pC13.7.10
Rib									
				<u>cation</u>	Loc Qty		Loc Code	7	397735 <del>-&gt; (</del> [
			W	A004	4				
				94721	4				<u></u>
			W	A005	1				
				88637	1				//
D3913-15	Manuf	actured	No	-	100	Each	15.0000	1	1. OC13-7-11
Wide Handle Plate					•				
			<u>Lo</u>	<u>cation</u>	Loc Qty		Loc Code	`.	B100417
		-	W	A003	10				<u></u>
				100417	10				<del></del>
			W	A004	5				
				97719	5				- //
D3913-3	Manuf	actured	No		100	Each	5.0000	1	10613.7.10
Rib									B100444 -
			<u>Lo</u>	<u>cation</u>	Loc Qty		Loc Code		3100444 <del></del>
			W	A004	3				
				97728	2				
				97973	1				
			W	A005	2			<del></del>	
				69160	1				<u></u>
				84651	1			-	<u></u>

											DQA:	Dat	te: _	
NCR: Y	es /	No				WORK ORDER NON-C	10:	<b>VFORM</b>	MANCE / UPI	DATE				
											QA Closed:	Dat	te:	
Work Orde	, ė.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part N	Part No. Rework Skid-tube Crosstube Machining Small Fab						Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other				
Root	$\overline{}$			ſ	Descri	ption of work order update	_	nitial	Act	tion	Sign &		Т	
Cause		ate	Step	Qty		or Non-conformance		ief Eng		ription	Date	Verificatio	n	QC Inspector
Doc/Data												1		
Equip/Tooling			•											
Operator			•										- 1	
Material		1	ŧ											
Setup														
Other														
Process							1				: -		l	
Supplier		,	, ,				ļ							
Training		` '	, v	ł										
Unapproved			-	Ϊ΄			İ						- 1	
	<u> </u>					F	AUL	T CATE	GORY					
Landi	ng Gea	r	-			General		_			_			
	Be	nding				Bend		Grain			Ovalized	:		Pressure/Forced
	Ce	ntre No	t Cònce	ntric to	o/s	BOM/Route	Г	Hardwa	ire		Over/Under	tolerance		Temperature/Cure
	Cra	acks -				Broken/Damaged		inspect	ion Incomplete		Part Incorre	ct		Weld
	Cru	ushed/0	Crimped			Burrs		Instruct	tions Incomplete/l	Unclear	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cu	ffs				Contamination		Mainte	enance		Part Moved	·		
	He	at Trea	t			Countersink	Г	Mislabe	eled		Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short						Misread	d		Power Loss/	Surge		Other	
	Ripples in Bend Drill Holes						Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

May-27-13 8:41:39 AM

Work Order ID:	102108							
Parent Item:	D3913-041					Star	t Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base Assemby, 350					Sta	rt Qty: 1.00	Required Oty: 1.00
<b>D3913-7</b> Rib	Manufactured	No		100	Each	2.0000	2	2 (06/3.7
			Location	Loc Qty		Loc Code		3 10048# -
			WA004	1				_
			94742	1				
			WA006	1				
			98451	1				_ /
D3913-9 Hinge Rib	Manufactured	No		100	Each	3.0000	1	(pC13.7.1
			Location	Loc Qty		Loc Code		Diagonil.
			WA005	3				310030Y-
,			70138	1				_
			97910	2				_ /
D3916-041	Manufactured	No		100	Each	4.0000	2	2(p(13.7.1
Rib Assembly								
			<b>Location</b>	Loc Qty		Loc Code		丑100857-
			WA004	2				_ \$
			10035	1				<del></del>
			97938	1				<del></del>
			WA005	2			<del></del>	
			81444	2				- //
D3916-5	Manufactured	No		100	Each	10.0000	3	36pC13.7.18
Light Rib							C	
			<b>Location</b>	Loc Qty		Loc Code		3100439-
			WA004	5				_
			94698	2				_
			97725	3				_
			WA005	5				_
			77142 82933	1				<del>_</del>

								DQA:	Date:					
es / No			W	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:										
r:		÷		DISPOSITION AGA				PARTMENT	/PROCESS					
0.				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor	Engineering Quality				
0.}				Use-as-is Work Order Update	Therr	noforming Large Fab	Finishing Composite	-						
			Description	of work order update	Initial	Ac	tion	Sign &						
Date	Step	Qty	or No	n-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector				
								i						
	· .					·								
•	: o. <u>}'</u>	). (). (). ().		Description	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Description of work order update	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Description of work order update  Initial	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Description of work order update  Description of work order update  DISPOSITION  Skid-tube Machining Thermoforming Large Fab  Active Machining Thermoforming Large Fab	DISPOSITION  Rework Skid-tube Crosstube Machining Small Fab Thermoforming Large Fab Composite  Description of work order update Initial Action	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed:  DISPOSITION  Rework Scrap Use-as-is Work Order Update  Description of work order update  Description of work order update  O. Description of work order update  Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update  O. Description of work order update	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:  DISPOSITION  Rework Scrap Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machining Machi				

## Unapproved **FAULT CATEGORY Landing Gear** General Bend Ovalized Pressure/Forced Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short Offset Drill Holes Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Other Process Supplier Training May-27-13 8:41:39 AM

Work Order ID: Parent Item:	102108 D3913-041		•			644	Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base Assemby, 350						Qty: 1.00	Required Qty: 1.00
D4016-1 Hinge Half, Base	Manufactured	No		100	Each	46.0000	3	3 Cp(17-7./
			<u>Location</u>	Loc Qty		Loc Code	7	94481-
		,	WA:	5			4.~	, , , , , , ,
			97664	5				_
		,	WA004	30				_
			100265	30				_
		,	WA005	11				_
			94481	11				
<b>4017-7</b> ib	Manufactured	No	<i>7</i> 1101	100	Each	15.0000	1	1 (PC13-7-10) B100413-
		]	Location .	Loc Qty		Loc Code		B100413-
		,	WA004	1				1.00 (10
			94149	1				_
		,	WA005	14				_ 
			100413	10			-	_
			69730	1				_
			82969	1				<del>-</del>
			85435	1				_
			88392	1				
4017-9	Manufactured	No		100	Each	15.0000	2	2 (Pl13.7.10
b			Location	Loc Qty		Loc Code	7	100537 -> (
			WA004	12		<u> Loc Couc</u>	4	10033 /
								_
			100537	12				_
			WA005	3				<del>-</del>
			70341 81445	2				_

NCR.	Yes	1	Nο

											DQA:	Date:	•
NCR: Y	'es /	No				WORK ORDER NON-	COI	<b>VFORM</b>	MANCE / UPI	DATE			
· · · · · · · · · · · · · · · · · · ·											QA Closed:	Date:	
Work Orde	r.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
. Part N			-			Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			<b>—</b>	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo				<u> </u>	Work Order Update							
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Da	te	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling	_	l											
perator													
/laterial													
etup													
Other													
rocess		1											
upplier													
raining													
Inapproved					:				<u> </u>			<u> </u>	L
							FAUI	T CATE	GORY				
Landi	ng Gear				<b></b>	General	r	1		Γ-			1
	Ben	ding	•		.	Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced
	_		t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		<b> </b>	Over/Under		Temperature/Cure
	Crac				L	Broken/Damaged	_	4	ion Incomplete		Part Incorre	<del></del>	Weld
	_		Crimped		<u> </u>	Burrs	<u> </u>	4	tions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuff				<u> </u>	Contamination	$\vdash$	Mainte			Part Moved		
	Heat Treat Countersink				$\vdash$	Mislabe		-	Positioned V		1		
	Inspection Strip in Tube Cut Too Short				$\vdash$	Misread	d	L	Power Loss/	Surge	Other		
	<b>—</b> ''		Bend		<u> </u>	Drill Holes	_	Offset					
	<del></del>		aves in E		n	Drawing	Out of Calibration						
	<del></del> -	_	equence			Finish	$\perp$	-1	Sequence				
	Wave/Twist in Tube Folio							Outside Dimensions					

May-27-13 8:41:40 AM

Work Order ID: Parent Item: Parent Item Name:	102108 D3913-041 Long Basket Base Assemby, 350						Date: 5/27/13 Qty: 1.00	Required Date: 6/05/13  Required Oty: 1.00
D4020-11 End Mesh, Basket	Manufactured	No		100	Each	7.0000	2	2 (2013.7.10
·			Location WA007 100650 81442	Loc Oty 7 4 2 2		Loc Code	* <b>3</b>	102072 - 6 - -
D4021-1 Handle Plate	Manufactured	No	84972	100	Each	75.0000	3	3 Cp(13.7.1
		-	Location WA004 100366 100649 \$ 94596 97940	Loc Oty 75 54 16 3 2		Loc Code	<b>3</b> 3	100649 <del></del>
D4021-5 Blanking Plate	Manufactured	No		150	Each	8.0000	$\frac{1}{2}$	2 BLB-7-11
			ST084 /20 344 85065 98260	Loc Otv 8 2 6		Loc Code	_&_	  0
D4034-041 Aft Upper Rib Assembly	Manufactured	No		100	Each	6.0000	1	16613.7.10
			Location WA004 94813 94977 WA005 100301 84048	Loc Oty 2 1 1 4 3 1		Loc Code		1 (pc,3.7.10 B 100301 - (i

NCR:	Yes		No
NCA.	162	,	IVU

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR: Y	es / No				WORK ORDER NON-C	טוארטג	IVIAINCE / UP	<i>UATE</i>	QA Closed:	Date	<b>:</b>
Nork Orde	··	· · · · · · · · · · · · · · · · · · ·	<u></u>		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	ľ	Water Jet d. Eng. Coor.	Engineering Quality
NCR No. Use-as-is Work Order Update						Ther	moforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
quip/Tooling prerator Material etup other process supplier raining											
		1	1 1		F	AULT CAT	EGORY		·	1	
Landin	g Gear				General						
. ~	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruction Maint Mislat Misrea Offset	tion Incomplete ctions Incomplete/ cenance celed ad	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ŀ	<b>→</b> `	Sequence			Finish	$\vdash$	Sequence				
	Wave/Twist in Tube Folio				Outside Dimensions						

May-27-13 8:41:40 AM

Work Order ID: Parent Item:	102108 D3913-041						Start I	Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base	Assemby, 350					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
D4034-043		Manufactured	No		100	Each	6.0000	1	1 /// - 5 /5
Fwd Upper Rib Assemb	ly .							·	(pc13.7.10
				Location	Loc Qty		Loc Code		B100288
•				WA004	1				
				100286	1				
				WA005	5				
				100288	3				
				82980	2				
D4672-1 Blanking Plate		Manufactured	No		100	Each	18.0000	2	2 (p(13.7.10
Diaming France				Location	Loc Qty		Loc Code	100819	1 <del>3101186 &gt; (</del> 3
			,	WA004	14		_		
	,			101186	14				
				WA005	4				
				88253	4				
M304EX0.75-16F Expanded Metal Flat SS	<b>,</b>	Purchased	No		100	sf	1,289.8151	33	33 GC 13.7.10
				Location	Loc Qty		Loc Code	m	126052-33)
				MAT	176.2791180			* * *	126038 - 30
				125113	176.279118				
				WA	414				
				125457	. 414				
				WA007	699.536				
				123448	15.96			**************************************	
•				125457	203.576				
				125605	480				

											DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPDATE		QA Closed:	Da	ite:	
						DISPOSITION			AGAINS	T DE	PARTMENT			
Work Ord	er:					1	_							
Part	No.					Rework Scrap Use-as-is		1	Skid-tube Crosstub Machining Small Fa noforming Finishir	ıb	4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR	No.⁻̯		•			Work Order Update	1	1110111	Large Fab Composit		]	Supplier	_	
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	C	hief Eng	Description		Date	Verificatio	'n	QC Inspector
Doc/Data							Т					ì		
Equip/Tooling														
Operator					i		Ì							
Material			1											
Setup														
Other														
Process														
Supplier														
Training			Ì											
Unapproved	$\perp$					·								
		*		•		<del></del>	FAU	LT CATE	GORY					
Land		1			г	General		٦		_	٦		_	1
	$\vdash$	Bending				Bend	$\vdash$	Grain		$\vdash$	Ovalized		$\vdash$	Pressure/Forced
		Centre N	ot Conce	ntric to	O/S	BOM/Route	$\vdash$	Hardwa		$\vdash$	Over/Under tolerance			Temperature/Cure
	$\vdash$	Cracks			1	Broken/Damaged	$\vdash$	<b>⊣</b> `	ion Incomplete	$\vdash$	Part Incorre		$\vdash$	Weld
1	1	Crushed/	Crimped (		1	Burrs	1	Instruct	tions Incomplete/Unclear	1	Part Lost/Mi	issing	1	Wrong Stock Pulled

Maintenance

Out of Calibration Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

May-27-13 8:41:40 AM

Work Order ID: Parent Item: Parent Item Name:	102108 D3913-041 Long Basket Base Assemby, 350				Date: 5/27/13  Oty: 1.00	Required Date: 6/05/13 Required Qty: 1.00
MS20600-AD4W3 Cherry Rivets	Purchased	No	150 Eacl	h 1,119.0000	2	BK 13-7-11
		Location	Loc Qty	Loc Code		••
	•	ST311	986			
		122151	4			
		122452	4			
		123525	294			
		124231	684		~	
		WA003	133			
		107939	133			
AS21042L3	Purchased	No	150 Eacl	h 3,253.0000	6	6 Bel 13-7-11
lut					. y	Value of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same
		Location 22/	Loc Qty	Loc Code	6	
		FP001 126036	3			
		122141	3			
		GA	18			
		122452	18			
		ST314	268			
		117885	32			
		119017	55			
		119075	138			
		123265	43			
		ST506	2964			
		123900	954			

2010

124291

NCR:	Yes	/	No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	CONFC	ORIV	IANCE / UP	DATE	QA Closed:	Date	:
Marile Order					DISPOSITION				AGAINST DE			<u> </u>
Work Order Part No					Rework Scrap			Skid-tube	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Work Order Update	Th	Thermoforming Finishing Large Fab Composite			-}	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	al	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	Eng	Desc	ription	Date	Verification	QC Inspector
Ooc/Data							ŀ					
quip/Tooling		1									1	
Operator						ļ i						
√aterial												
etup	_	Ì										
Other	_											
Process												
Supplier										1		
raining						1	- 1					
Jnapproved		<u> </u>	<u> </u>			<u> </u>				<u> </u>		
					<del></del>	AULT C	ATEG	GORY				
Landin				_	General				_	7	<u></u>	
	Bending	-		<u> </u>	Bend	Gra			ļ	Ovalized	<u>_</u>	Pressure/Forced
-	Centre No	ot Conce	ntric to (	D/S	BOM/Route	$\boldsymbol{\vdash}$	rdwar			Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	<u> </u>	•	on Incomplete	<u> </u>	Part Incorre	<b>—</b>	Weld
Ļ	Crushed/	Crimped		<u> </u>	Burrs	$\blacksquare$		ons Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ĺ	Cuffs	Cuffs Contamination			$\vdash$		nance		Part Moved			
	Heat Treat Countersink				Mis	slabel	ed		Positioned V			
	Inspection Strip in Tube Cut Too Short			<b>=</b>		sread			Power Loss/	Surge	Other	
L	Ripples in Bend Drill Holes			Offset								
	Torque V			՝ L	Drawing	Out of Calibration						
	Turning S				Finish	Out of Sequence						
ŀ	Wave/Twist in Tube			Folio	Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-27-13 8:41:41 AM

Work Order ID:

102108

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

NAS1149F0332P

WASHER

Purchased

No

**Start Date: 5/27/13** 

Required Date: 6/05/13

Start Qty: 1.00

12

Required Qty: 1.00

12,498.000 12

150

Each

Location	<u>n</u>	Loc Qty	Loc Code	•	
GA		182		<del></del>	
	122063	182			
ST294		158			
	122063	158			
ST295		3			
	123352	3			
st510	/	7155			
	123900	7155		_/2_	
ST510a		5000			
	125646	5000			

											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	<b>VFORM</b>	AANCE / UP	DATE		D-1	
								· ·			QA Closed	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-					Rework Scrap		Skid-tube Crosstube  Machining Small Fab			Pro	Water Jet od. Eng. Coor.	Engineering Quality
, raiti	•0. –					1 'b			Finishing	4	re/Packaging	Other	
NCR No.					···	Work Order Update Large Fab Composite			~ <del></del>	ince, sto	Supplier		
Root					Descri	ption of work order update	ı	nitial	Ad	ction	Sign &		
Cause	ı	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data										_	- "		
Equip/Tooling													
Operator		,			Ì		Ì.						
Material					<u>.</u>								
Setup													
Other									·				
Process							İ						
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY	<del></del>			
Landi	ng G	ear				General		-			_	<b>,</b>	7
		Bending			<u> </u>	Bend		Grain		<u></u>	Ovalized		Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	Weld	
	Crushed/Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/N	lissing	Wrong Stock Pulled		
		Cuffs				Contamination			Part Moved	I			
		Heat Trea	it			Countersink		Mislabe	eled		Positioned	Wrong	-
	Inspection Strip in Tube					Cut Too Short	Misread			Power Loss	/Surge	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

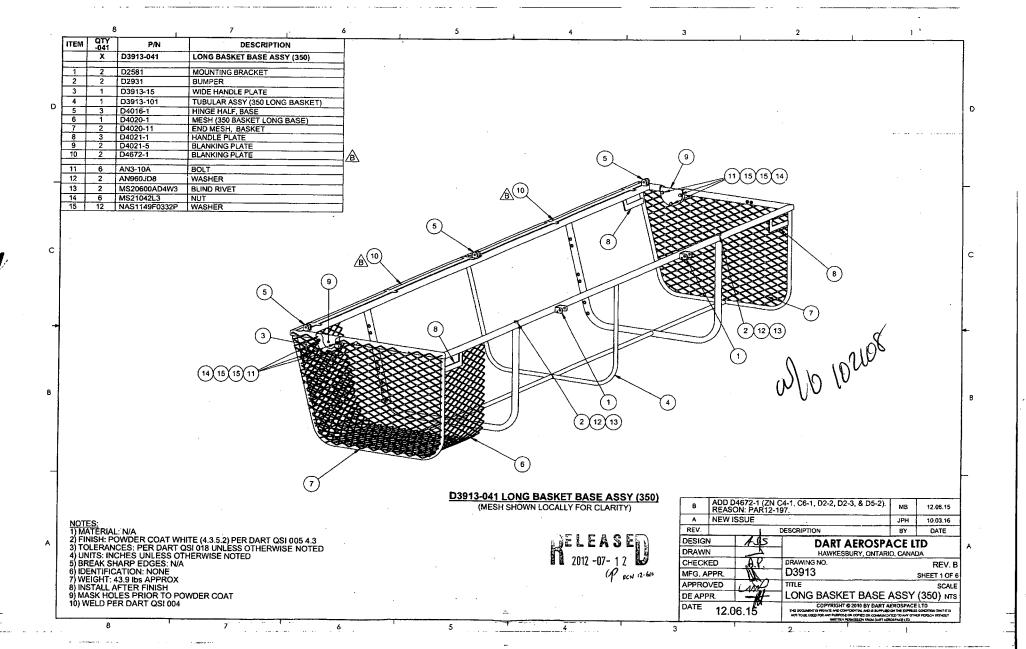
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

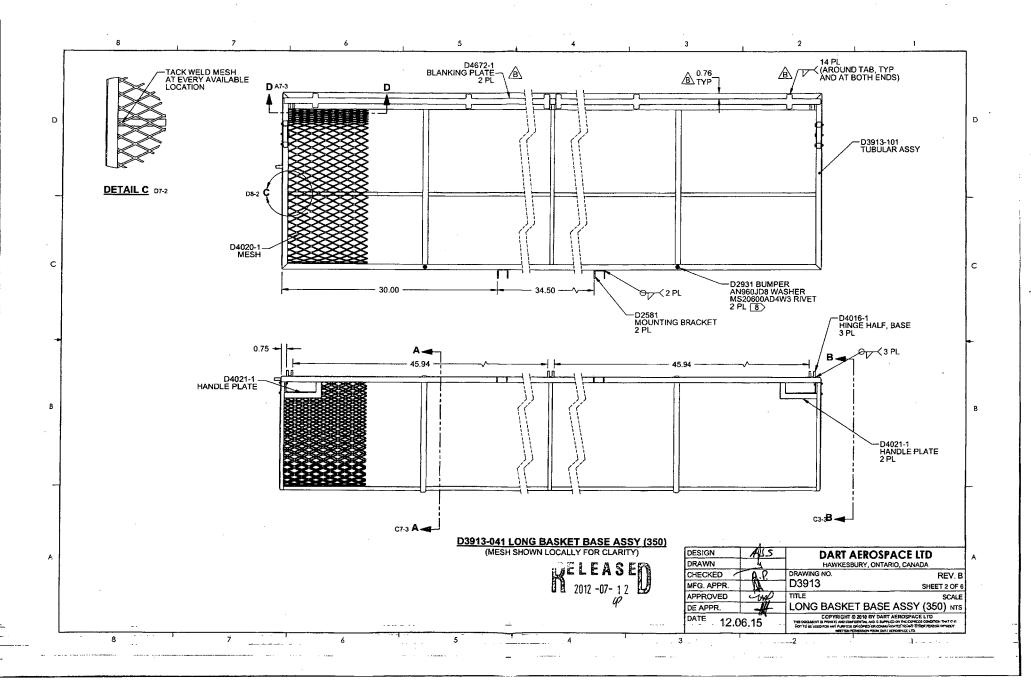


NCR:	Yes	/	No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_Date: \_\_\_\_\_

NCR: Ye	s / No				WORK ORDER NON-	CON	MFORI	MANCE / UPL	DATE	QA Closed:	Date	<b>:</b> :
Work Order	•				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Order	•				Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering
Part No	)				Scrap	<b>.</b>	Machining Small Fab			-1	d. Eng. Coor.	Quality
	Use-as-is			╛╻		noforming	Finishing Composite	Rec/Stor	e/Packaging	Other		
NCR No	CR No Work Order Update				╛╏		Large Fab	Supplier				
Root				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data	1											
quip/Tooling	7					}						
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	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct _	Weld
	Crushed/	Crimped			Burrs		instruct	ions Incomplete/U	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
[	Torque V	Vaves in I	Extrusio	n	Drawing		Out of	Calibration				
ſ	Turning S	Sequence	<u> </u>		Finish	Out of Sequence						
<u> </u>	Ways /Twist in Tube				10	Dimonsions						



										DQA:	Date:					
NCR: Y	es /	No				WORK ORDER NON-C	CONFORI	MANCE / UF	PDATE	QA Closed:	Date:					
Work Orde	r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
						Rework	]	Skid-tube Crosstube			Water Jet	Engineering				
Part No.						Scrap	- I	Machining Small Fab			d. Eng. Coor.	Quality				
NCR No.						Use-as-is Work Order Update	Therr	Thermoforming Finishing  Large Fab Composite			re/Packaging Supplier	Other				
Root					Descri	ption of work order update	Initial	A	ction	Sign &						
Cause	D	ate	Step	Qty	(	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector				
Doc/Data																
Equip/Tooling		ł														
Operator		İ					į									
Material											!					
Setup																
Other							1									
Process																
Supplier	7															

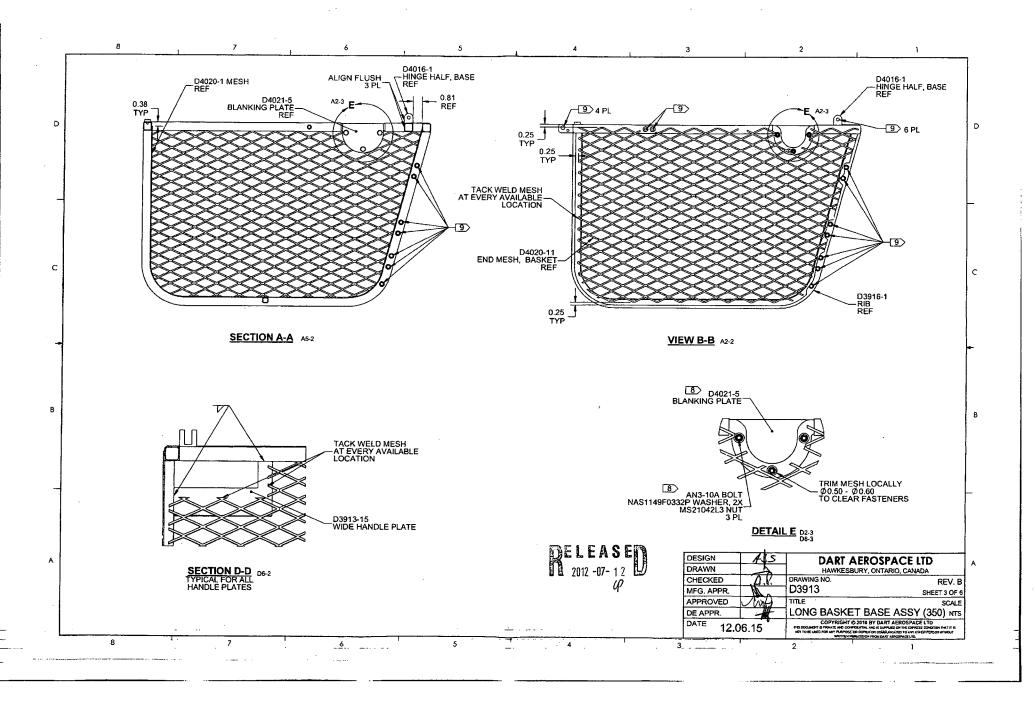
## **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bending Bend Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Countersink Positioned Wrong Mislabeled **Heat Treat** Other Power Loss/Surge Inspection Strip in Tube Misread Cut Too Short Drill Holes Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Training Unapproved

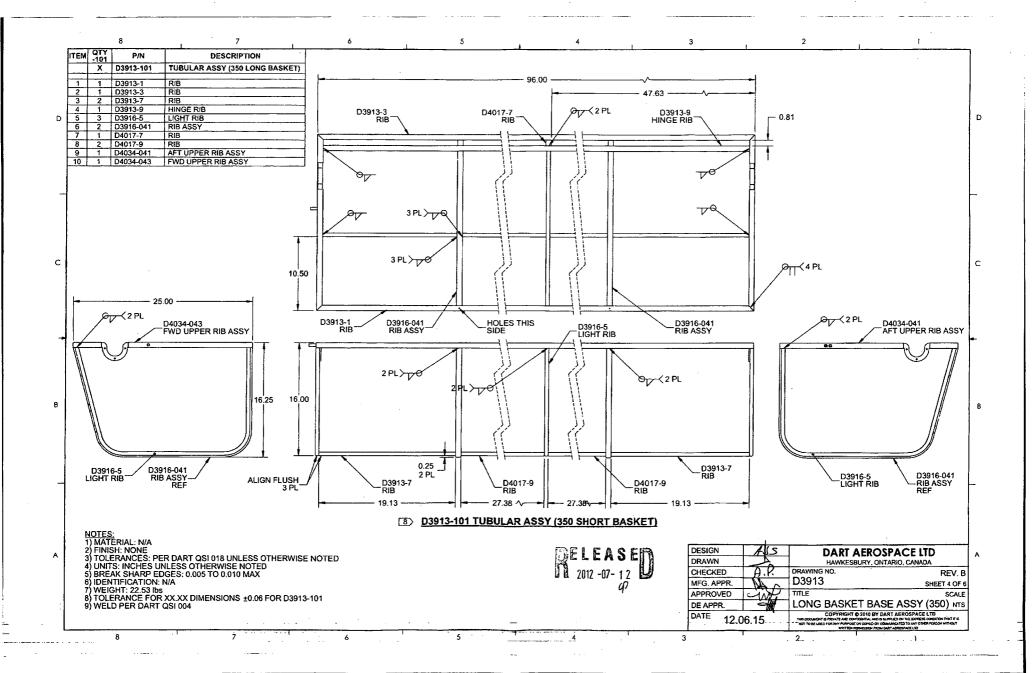


NCR.	Yes	/	Nο

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_

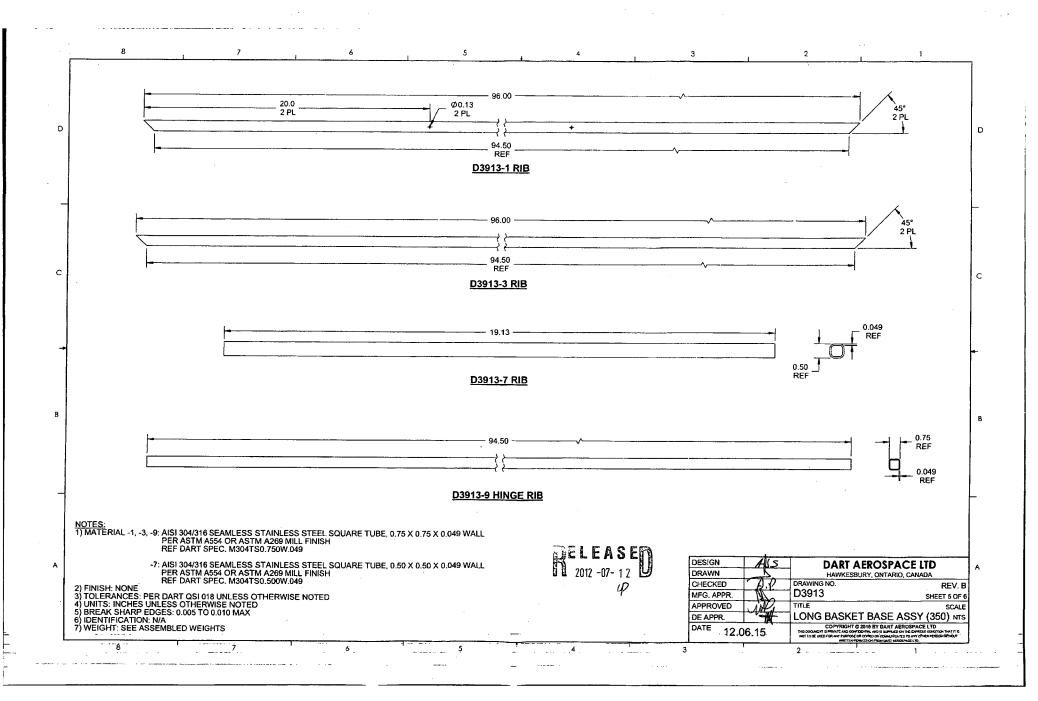
NCR: TO	es / NO				AAOUK OUDER IAOIA-	COIN	FUNN	MAINCE / OF		QA Closed:	Date	e:
Work Orde	÷-				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIGE	· —				Rework	7 I		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	0.				Scrap	<b>1</b>		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, 2, 2, 1					Use-as-is	┪╽.		noforming	Finishing	4	re/Packaging	Other
NCR N	0.				Work Order Update	<b>7</b> ]		Large Fab	Composite		Supplier	7 7 1
										-		
Root				Descri	iption of work order update	Ini	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_											
quip/Tooling												
Operator												
Material							- 1					
Setup	_		1									
Other												
Process												
Supplier	_											
Fraining [												
Jnapproved										<u> </u>		<u> </u>
						FAULT	CATE	GORY				
Landin	g Gear			_	General				_	_	_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (	o/s	BOM/Route	⊢∐⊦	lardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			L	Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
[	Cuffs				Contamination			nance		Part Moved		
	Heat Treat Countersink					∕Iislabe	led		Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short					Misreac	1		Power Loss/	Surge	Other	
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in I	Extrusion	, [	Drawing		Out of C	Calibration				
	Turning S	Sequence	!		Finish	Out of Sequence						
1	<b>─</b>				Folio	Outside Dimensions						



NCR:	Yes	/	No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

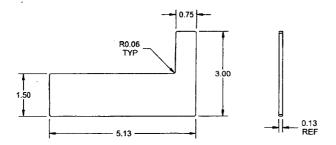
NCR: Ye	es / No				WORK ORDER NON-C	CONI	FOKIN	MANCE / UPI	DATE	QA Closed:	Date	:	
Work Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap		Skid-tube Crosstube  Machining Small Fab				Water Jet	Engineering Quality	
NCR No.					Use-as-is Work Order Update		Thermoforming Finishing  Large Fab Composite						
Root				Descri	ption of work order update	Ini	itial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data	_		1								:		
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Operator	_	  - 											
Material	_					1							
Setup	_												
Other													
Process	4												
Supplier	4												
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Jnapproved		<u> </u>					CATE	CODY	<u></u>				
	-				<del></del>	AULI	CATE	JURY					
Landing	_				General Bend		Grain		_	Ovalized	Г	Pressure/Forced	
-	Bending	-4 6	-4-i- 4- C	\s_  -	BOM/Route	.—			-	Over/Under	toloranco	Temperature/Cure	
	Centre No	ot Concei	ntric to C	"³	=	<del></del>	lardwa		<del></del>	Part Incorred	<b>)</b>	Weld	
-	Cracks	C		⊢	Broken/Damaged	-	•	on Incomplete	Unclose	-1	<b> </b>	Wrong Stock Pulled	
<u> </u>	Crushed/Crimped				Burrs		Instructions Incomplete/Unclear  Maintenance		Unclear	Part Lost/Missing Wrong Stock Pulled Part Moved			
-	Cuffs Heat Trea			-	Contamination Countersink	$\mathbf{H}$	viairite Mislabe		-	-1	Vrong		
	Inspectio		Tubo	$\vdash$	Cut Too Short	$\vdash$	viisiabe Viisreac		-	Positioned Wrong Power Loss/Surge Other		Other	
-	Ripples in	-	iube	<u> </u>	Drill Holes	-	viisreac Offset	•	L.	T. OMEL FOSS	Juige _	Totalei	
-	Torque W		vtrucion	, ⊢	Drawing	$\boldsymbol{\vdash}$		Calibration					
<b> -</b>	Turning S			` <u> </u> -	Finish	$\vdash$		Sequence		<del></del>			
<b> </b>					Folio	$\vdash$		Dimensions					
Wave/Twist in Tube					1. 0	1 1		CII310113					



NCR: Ye	$\cdot$											
										QA Closed:	Date	):
Work Order	:				DISPOSITION	_	AGAINST DEPARTMENT/				PROCESS	
Part No.					Rework Scrap	-	Skid-tube Crosstube Machining Small Fab			Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.				Use-as-is Thermoforming Finishing			Finishing Composite					
Root				Descr	iption of work order update	<del></del>	nitial	Acti	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data quip/Tooling												
Operator Material												
Setup	_						,					
Other												
Process	_											
Supplier												
raining	_	İ										
Jnapproved		<u> </u>	ļ				TCATE	CORY				
						FAUL	T CATE	GORY				
Landing	_			Γ-	General		Grain		Г	Ovalized	Г	Pressure/Forced
-	Bending			o/s	Bend	$\mathbb{H}$			-	Over/Under	+=loronaa	Temperature/Cure
-	Centre No	ot Concer	itric to	<sup>5/5</sup>  -	BOM/Route Broken/Damaged	$\vdash$	Hardwa	re on Incomplete	<u> </u>	Part Incorre	<del> </del>	Weld
-	_	Crimpod		-	Burrs	$\vdash$	i .	ions Incomplete/U	Inclose	Part Lost/Mi	· · ·	Wrong Stock Pulled
	Crushed/	Crimpea		-	Contamination		Mainte	•	-	Part Moved	22111g	wrong stock runed
	H				=======================================	$\vdash$	Mislabe		_	Positioned V	Vrong	
	Heat Trea		Tubo		Countersink Cut Too Short		Misread		-	Power Loss/		Other
-	Inspection	-	iupe	$\vdash$	Drill Holes		Offset	,	L	Trower ross/	Juige [	Jouren
-	Ripples in		uterrei –	<u> </u>	<b>-</b>		ł	Calibration				
-	Torque W			" <b> </b> -	Drawing	<u> </u>	•					
-	Turning S			-	Finish		1	Sequence				
į	Wave/Twist in Tube   Folio						Outside Dimensions					

Date:

DQA:



**D3913-15 WIDE HANDLE PLATE** 

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-5-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304511GA
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

DESIGN	415	5	DART AEROSPACE LTD
DRAWN	5		HAWKESBURY, ONTARIO, CANADA
CHECKED	AV		DRAWING NO. REV. B
MFG. APPR.	M	_	D3913 SHEET 6 OF 6
APPROVED	: 11	Z)	TITLE SCALE
DE APPR.	4	_	LONG BASKET BASE ASSY (350) NTS
DATE 12.0	6.15		COPYRIGHT © 2010 BY DART AEROSPACE LTD  THE DOCUMENTS PRIVITE AND COMPEDITING, AND IS SUPPLED ON THE DOWNESS COMPONENT IN IN  NOT TO BE LIED FOR ANY PUPPOSE OF COPED OR COMMANDET ON YOUTH PRIVIDENT ANY OTHER PERSON WITHOUT -  WHATED PERSONS PROMISENT ASSOCIATED TO THE PERSON WITHOUT -

NCD.	V	,	NI.
NCR:	Yes	/	NO

Date:

NCR: Y	es / No				WORK ORDER NON-	·COM	FURIV	MANCE / UP	DATE	QA Closed:	Date	e:		
Work Orde	der: DISPOSITION							AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap	Machining Smal			Crosstube Small Fab	Prod. Eng. Coor. Quali		Engineering Quality		
NCR No.					Use-as-is Work Order Update		Thermoforming Finishi  Large Fab Composi							
Root		T		Descr	iption of work order update	In	itial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector		
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quip/Tooling	_						1							
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Inapproved		<u> </u>		· · ·				2004						
			·		<del></del>	FAULI	CATE	JORY						
Landin F	g Gear			Г	General		~ ·		<del></del>	Ovalized	Г	Pressure/Forced		
٠, ١	Bending				Bend	$\vdash$	Grain			-₹	<u> </u>			
		Not Conce	ntric to (	<sup>5/5</sup>  -	BOM/Route	-	Hardwai			Over/Under	F	Temperature/Cure		
75	Cracks			-	Broken/Damaged	-		on Incomplete	(11 m al n a n	Part Incorred	<u> </u>	Weld		
•		/Crimped		-	Burrs	_		ions Incomplete	Unclear	Part Lost/Mi	Issing [	Wrong Stock Pulled		
	Cuffs	_		-	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved	M			
	Heat Tro			-	Countersink	$\vdash$	Mislabe			Positioned V				
		on Strip in	Tube	-	Cut Too Short	$\vdash$	Misread	<b>l</b>	<u></u>	Power Loss/	Surge [	Other		
	Ripples			-	Drill Holes	-	Offset							
		Waves in I		Դ  -	Drawing	-		Calibration		-				
		Sequence		 	Finish	$\vdash$		equence						
- 1	Wave/Twist in Tube   Folio					1 (	Outside Dimensions							